

Date: Thursday, 19/03/2009 11:02:22 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : COMFORT SEAT KIT (FITS LH & RH)
Job Number : 46574	
Estimate Number : 13624	
P.O. Number :	Part Number : D205778011
This Issue : 19/03/2009 S.O. No. :	Drawing Number : IIN D205-778 U/R
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 43324	Material :
Written By :	Due Date : 30/03/2009 Qty: 4 Um: Each
Checked & Approved By : JUD 09.03.19	
Comment : Est Rev:A 08-10-20 New Issue DD verified by:EC	

Additional Product

Job Number:



FRAME pur 26

Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



for JUD 09/03/24



Comment: Photocopy bluefile & type labels per PPP D205-778-011 CHG 001

8 09/03/21

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0

D37521

Seat Frame



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Seat Frame

batch: 46514

4X

4.0

D3755041

Seat Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Seat Cushion

batch: 44543

4X

5.0

D3756041

Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Cushion

batch: 44544

4X

LC 9/27 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 11:02:22 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COMFORT SEAT KIT (FITS LH & RH)

Job Number: 46574

Part Number: D205778011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D3758041

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Clamp

batch: 43365 YX

7.0

D3777041

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Clamp

batch: 43366 YX

8.0

D38003200

Hook and Loop Strip (2" Hard)



Comment: Qty.: 0.5250 f(s)/Unit Total : 2.1000 f(s)
Hook and Loop Strip (2" Hard) measured 9/3/30

(cut 4 strip per kit to 6.00")

batch: 43367 46686 9/3/30

9.0

AN52510R8

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Screw

batch: 1108254 1108254

10.0

AN9703

Washers



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washers

batch: 1109754

11.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

batch: 1110523 9/3/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 11:02:22 AM
Usér: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COMFORT SEAT KIT (FITS LH & RH)

Job Number: 46574

Part Number: D205778011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

MS21042L3

Nut



(2x)

Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Nut

batch:

M110399

9/3/24

Ⓟ

13.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

802/03/31 (x2)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



(3x)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-778-101

Location:

PPP Rev:

9/3/31 54

Ⓟ

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/01 Ⓟ

Job Completion



mf
09-03-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

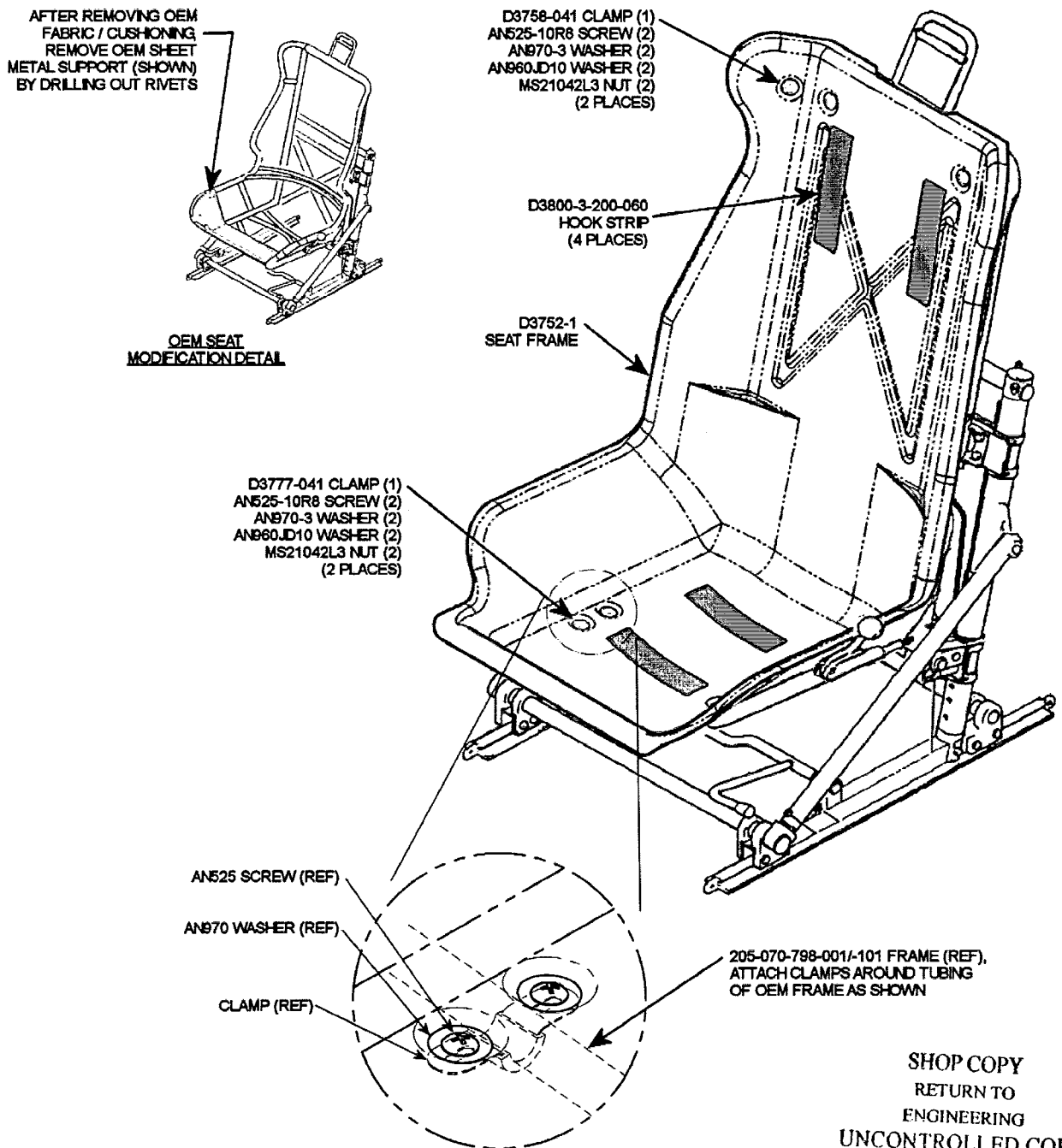


Figure 2: Installation of D205-778-011 Comfort Seat Kit

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46514

4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-778-011	13.0 lb	±22.0 in	±286 in-lb	47.0 in	611 in-lb
Comfort Seat Kit, LH / RH	5.9 kg	±0.56 m	±3.3 m-kg	1.19 m	7.0 m-kg

5.0 PARTS LIST

Qty -011	Part Number	Description
X	D205-778-011	COMFORT SEAT KIT (FITS LH & RH)
1	D3752-1	SEAT FRAME
1	D3755-041	CUSHION
1	D3756-041	CUSHION
2	D3758-041	CLAMP ASSEMBLY
*2	D3758-1	CLAMP
*2	D2182B028	RUBBER CUSHION
2	D3777-041	CLAMP ASSEMBLY
*2	D3777-1	CLAMP
*2	D2182B013	RUBBER CUSHION
4	D3800-3-200-060	HOOK STRIP
8	AN525-10R8	SCREW
8	AN970-3	WASHER
8	AN960JD10	WASHER
8	MS21042L3	NUT (OR MS21042-3)

* REFERENCE ONLY. PARTS ARE INCLUDED IN ASSEMBLY ABOVE.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 410574